

Date: Monday, 02/02/2009 4:02:08 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BASKET BASE ASS'Y (A119)
Job Number : 45428B	
Estimate Number : 12431	
P.O. Number :	Part Number : D3516041
This Issue : 02/02/2009 S.O. No. :	Drawing Number : D3516 REV C
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : LARGE FAB ASSY	Drawing Revision : C
Previous Run : 45427B	Material :
Written By :	Due Date : 01/04/2009 Qty: 1 Um: Each
Checked & Approved By : <u>JLD 09.02.03</u>	
Comment : EST rev. A 06.05.31 Preliminary EC	
EST rev. b 06.07.27 updated EC	
Est Rev:C 08-02-25 ECN 1138P DD verified by: LL	
Est Rev:D 08-03-18 ecn 1136 DD verified by:	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D34421	Shim
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
 Shim
 Batch: B 46767 → 2x SM 09/04/15

2.0	D2581	Mounting Bracket
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
 Mounting Bracket
 Batch: B 45684 → 2x SM 09/04/15

3.0	D351611	Clevis
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Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)
 CLEVIS
 batch: B 45714 → 6x SM 09/04/15

4.0	D351613	Clevis
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
 CLEVIS
 batch: B 45564 → 4x SM 09/04/15

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #:	Machine Or Operation:	Description :
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5.0	D23273	Spacer Bushing
-----	--------	----------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Spacer Bushing
Batch: B44365

PD 09-04-14

6.0	D22323	Basket Hinge
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Basket Hinge
Batch: B46626 → 2x

PD 09/04/15

7.0	D31661	Basket Hoop
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
RIB
Batch: B47072

PD 09-04-14

8.0	D37251	Hoop
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
HOOP
batch B45575

PD 09-04-13

9.0	M304TS0750W065	304 SQ Tube .75x.75x.065W
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Comment: Qty.: 53.1825 f(s)/Unit Total : 53.1825 f(s)
AISI 304 SQ Tube .75x.75x.065W
Batch: H111331

PD 09-04-13

10.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Cut rib D3516-1 as per dwg D3516 PD

2-Cut rib D3516-3 as per dwg D3516 PD

3-Cut rib D3516-5 as per dwg D3516 PD

4-Cut rib D3516-7 as per dwg D3516 PD

5- Cut rib D3516-15 as per dwg D3516 PD

PD 09-04-13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Drawing Name: BASKET BASE ASS'Y (A119)

Job Number: 45428B

Part Number: D3516041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6-Cut rib D3516-9 from D3166-1 (4) using DT8365 jig

PD 09-04-14

11.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld assembly as per dwg D3516

PD 09-04-16 / SJ 09/04/16

12.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

09-04-20

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Sotol 20/04

14.0

M304EX07516F

Expanded Metal Flat SS



Comment: Qty.: 60.0000 sf(s)/Unit Total: 60.0000 sf(s)

Expanded Metal Flat Stainless steel

Batch: M711173

M111444 (9.166)

SPD 09-04-20

15.0

LARGE FAB 1

(50.834)

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut expanded metal for base as per dwg D3516

2-Cut expanded metal for base ends as per dwg D3516

3-Weld expanded metal to base as per dwg D3516

SJ 09/04/21 (1x)

16.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

09-04-23

17.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Sotol 23/04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Job Number: 45428B

Part Number: D3516041

Job Number:



Seq. #:

Machine Or Operation:

Description :

18.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

1ST COAT:

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

***** 2nd coat if necessary*****

2ND COAT:

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

Pressure wash

UND/BK.

09/04/29

11/04/29

11:50

400°

12:20

BR 09-04-28

1:00

400°

1:30

BR 09-04-28

19.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL 09/04/29

20.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

PPD45428

85-09/04/29

21.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/04/30

Job Completion



MF 09-04-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

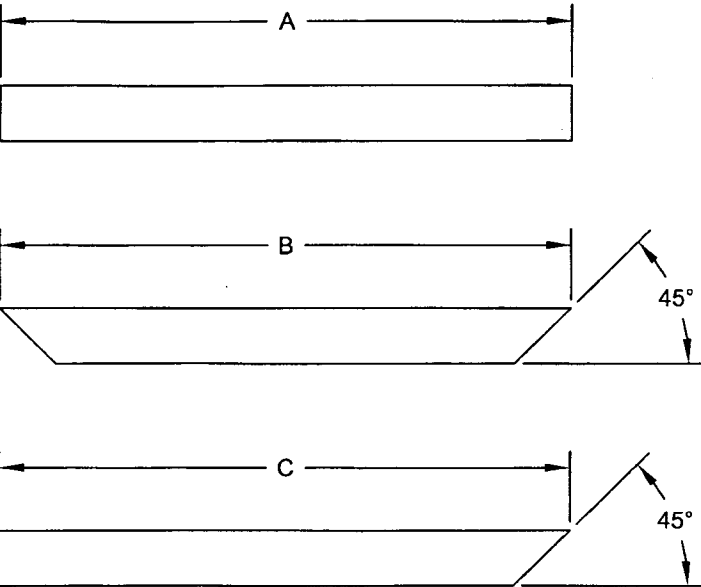
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

PARTS LIST FOR D3516-041 BASKET BASE ASSEMBLY

PART NO	QUANTITY	LENGTH A	LENGTH B	LENGTH C	DESCRIPTION
D2232-3	2	N/A	N/A	N/A	HINGE PLATE
D2327-3	2	N/A	N/A	N/A	BUSHING
D2581	2	N/A	N/A	N/A	MOUNTING BRACKET
D3442-1	2	N/A	N/A	N/A	SHIM
D3516-1	2	—	102.00	—	RIB
D3516-3	2	—	—	2.70	RIB
D3516-5	8	26.75	—	—	RIB
D3516-7	3	45.50	—	—	RIB
D3516-9	4	N/A	N/A	N/A	RIB (MAKE FROM D2235-3)
D3516-11	6	N/A	N/A	N/A	CLEVIS
D3516-13	4	N/A	N/A	N/A	CLEVIS
D3516-15	2	—	—	19.32	RIB
D3725-1	2	N/A	N/A	N/A	HOOP



D3516-041 BASKET BASE ASSEMBLY NOTES:

- 1) MATERIAL:
FRAME - AISI 304/316 STAINLESS STEEL SQUARE TUBING, 3/4 X 3/4 0.065 WALL
(REF. DART SPEC. M304TS0.750W.065)
MESH - 3/4-16F EXPANDED STAINLESS STEEL
(REF. DART SPEC. M304EX0.75-16F)
- 2) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE GLOSS (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 75 lbs
- 8) WELDING: PER DART QSI 004

C	ADD D3725-1 (ZNA7-3) AND D3516-15 (ZNA5-3), QTY.(1) PER END OF BASKET BASE; SHORTEN D3516-3 (REF. ECN#1136); REASON: CUSTOMER REQUEST	MB	08.02.20
B	ADD QTY.(4) D3516-13; QTY.(6) D3516-11 WAS QTY.(1) SEE TR-D119-756-1 REV. A	MB	06.07.25
A	NEW ISSUE	MB	06.06.21
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3516	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		BASKET BASE ASSEMBLY	NTS
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WITH DART
NO. H45428B

8

7

6

5

4

3

2

1

D3516-11
TYP BOTH ENDS, REFSKIN INSIDE SURFACE OF
BASKET WITH MESH.
TACK WELD EACH END OF
STRAND TO FRAME2.75
2 PLD3516-13
TYP BOTH ENDS, REFD3516-1
2 PLD3516-7
3 PLD3516-5
2X 4 PLD3516-3
2 PL, REF

25.50

DETAIL C

D3516-15
2 PL, REF

26.75

45.50

TYP

D2581
2 PL33.00
REF

33.00

34.50

D3516-11
CLEVIS, REFD2232-3
REFD3725-1
REFD3516-11 CLEVIS, REF
OR
D3516-13 CLEVIS, REF

73.77

D3516-7
3 PL

A

B

A

B

73.77

D3516-9

96.52
4 PL

B

102.00^{+0.01}_{-0.00}D3516-11
6 PLD3516-13
4 PL**D3516-041 BASKET BASE ASSEMBLY**

DESIGN		DART AEROSPACE LTD	
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MFG. APPR.		D3516	SHEET 2 OF 4
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DE APPR.		BASKET BASE ASSEMBLY (A119)	NTS
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8

7

6

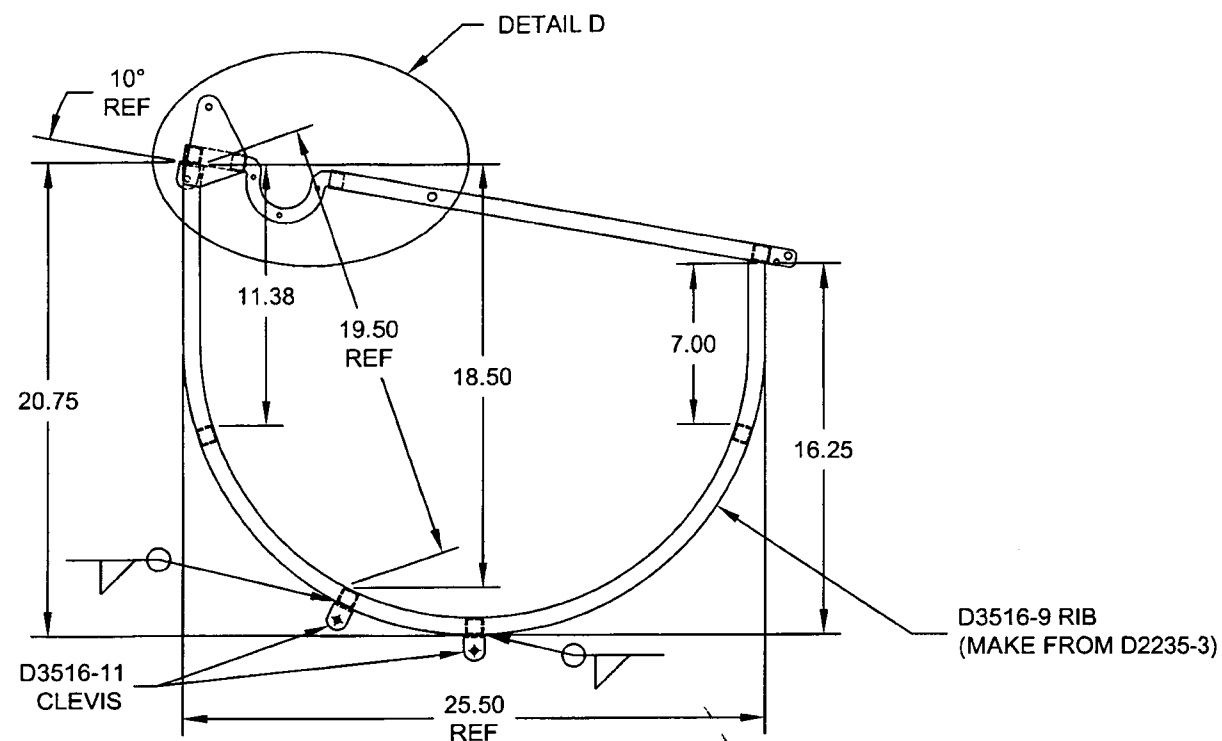
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4

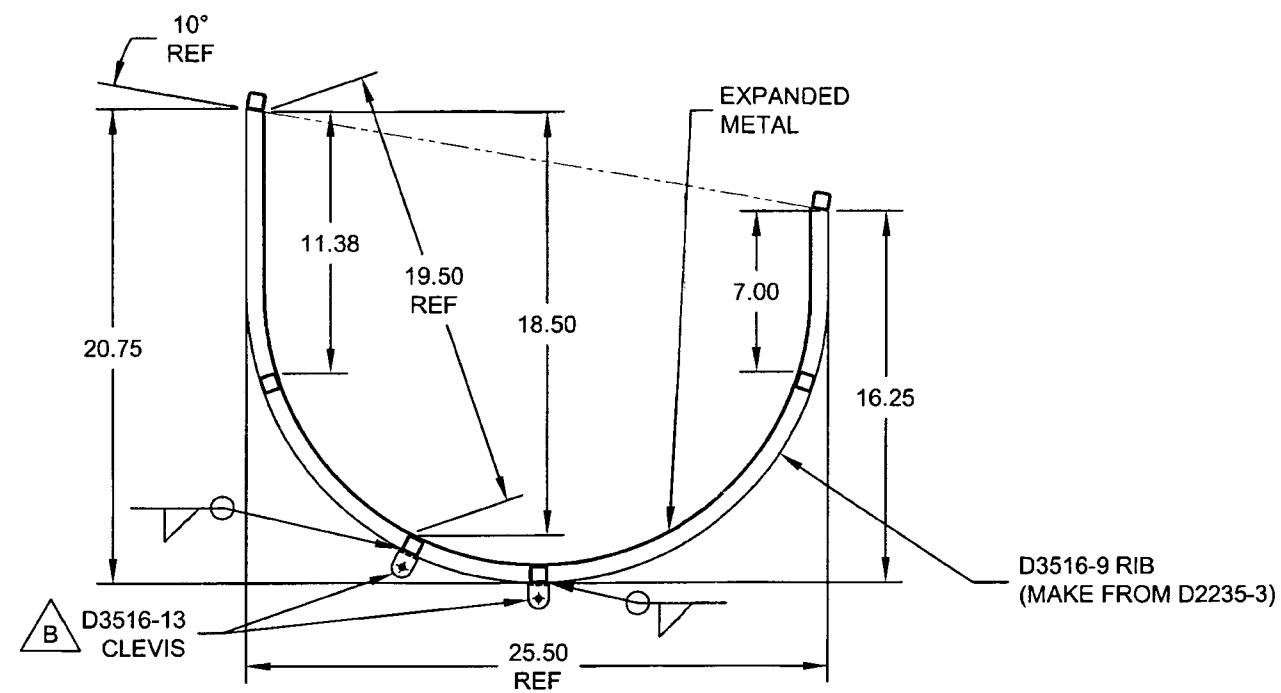
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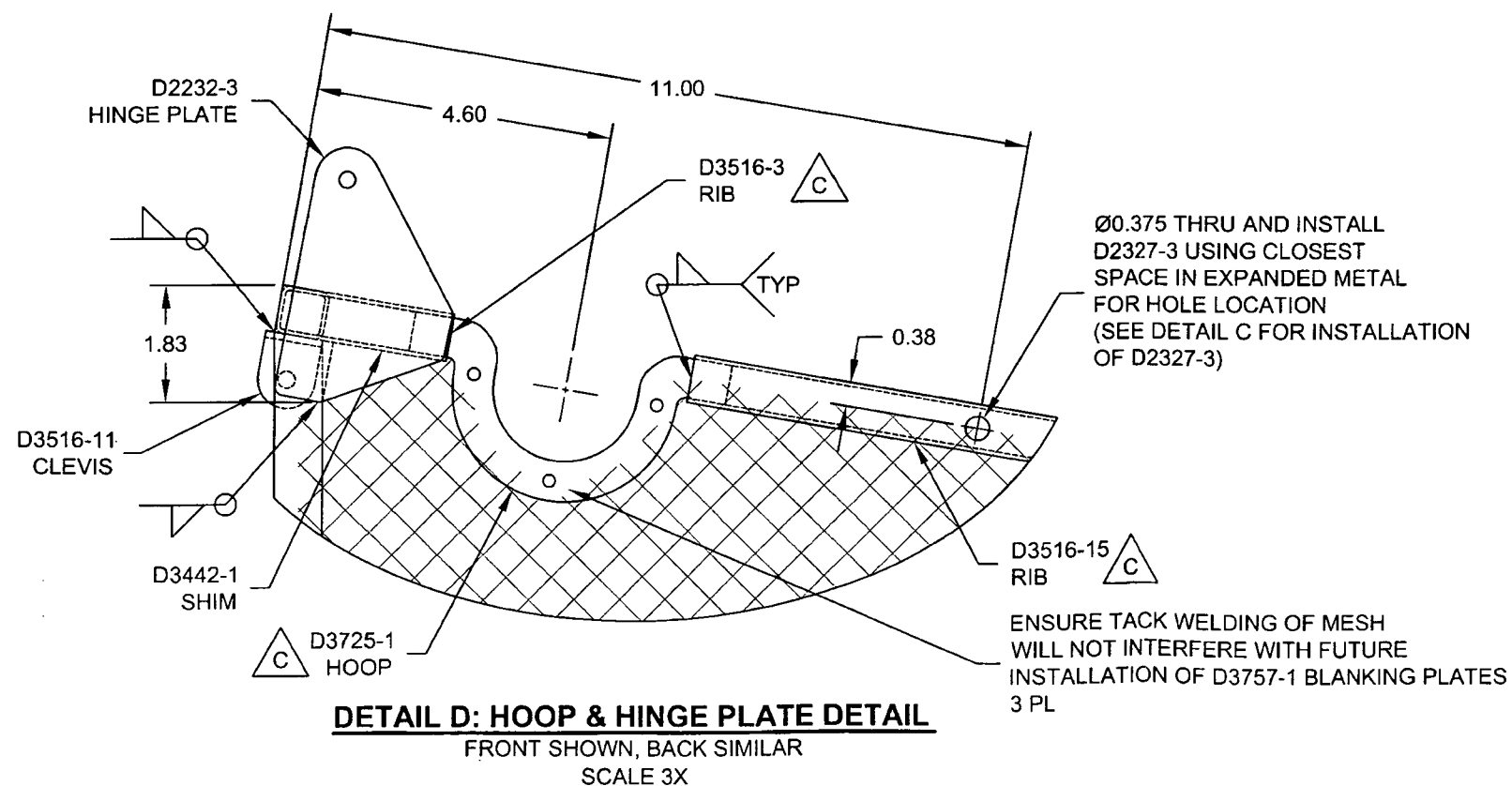
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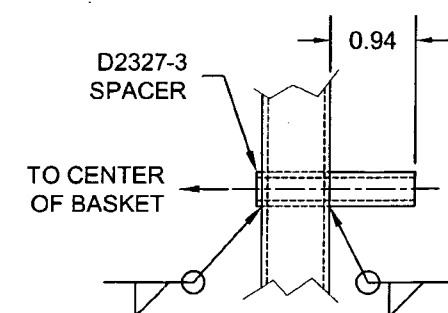
SECTION A-A: END RIB DETAIL
(MESH NOT SHOWN FOR CLARITY)
TYP BOTH ENDS



SECTION B-B: CENTER RIB DETAIL
2 PL



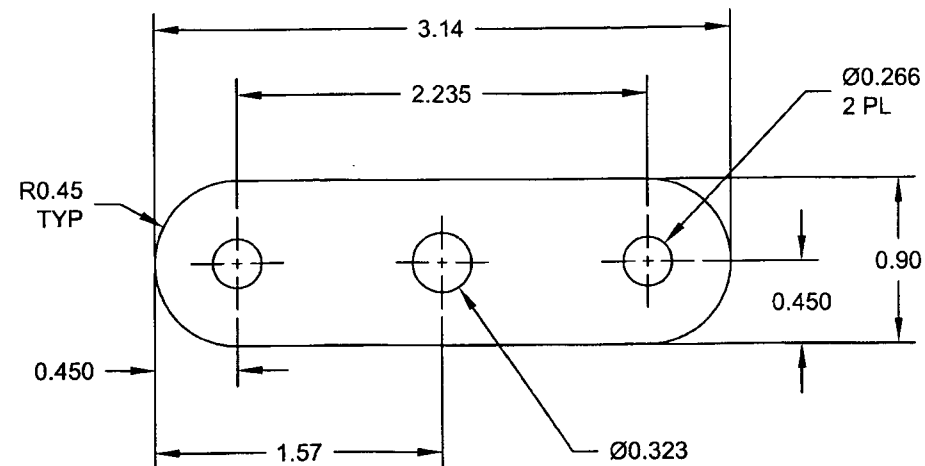
DETAIL D: HOOP & HINGE PLATE DETAIL
FRONT SHOWN, BACK SIMILAR
SCALE 3X



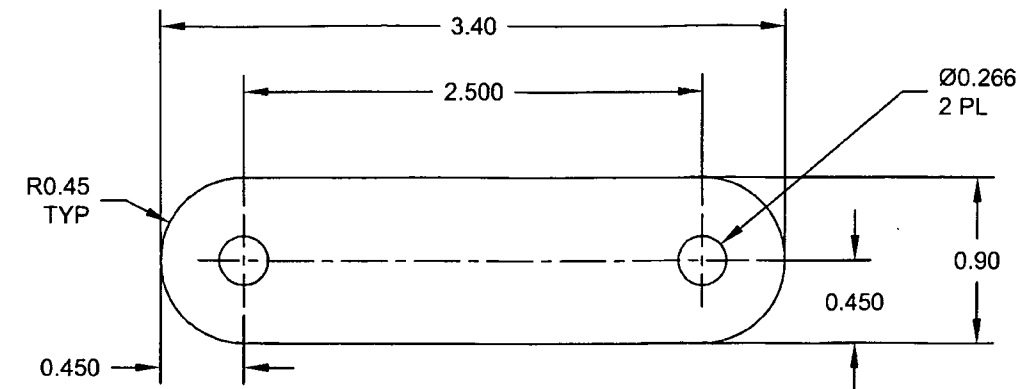
DETAIL C: SPACER INSTALLATION
SCALE 4X

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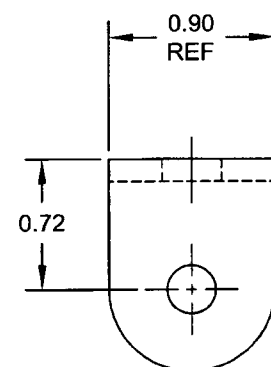
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CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3516	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		BASKET BASE ASSEMBLY	NTS
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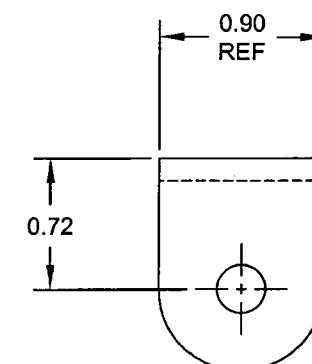
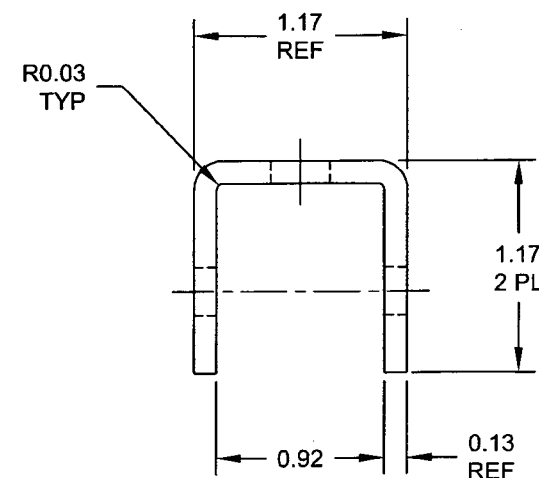
1 D3516-11F CLEVIS FLAT PATTERN



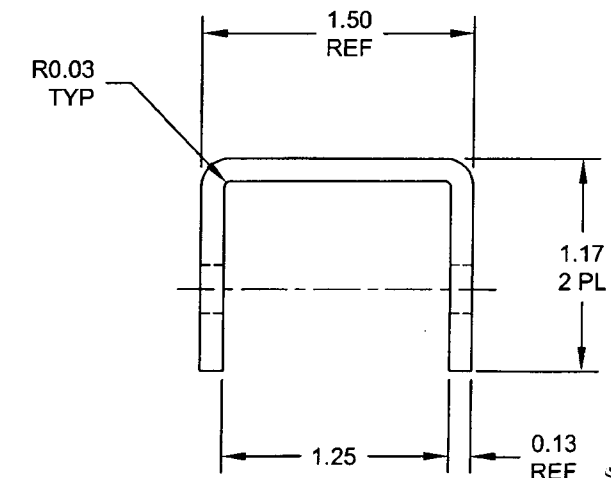
1 D3516-13F CLEVIS FLAT PATTERN



D3516-11 CLEVIS BENDING DETAIL
(MAKE FROM D3516-11F)







D3516-13 CLEVIS BENDING DETAIL
(MAKE FROM D3516-13F)



D3516-11/-13 NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR AMS 5524, 11 GAUGE (0.125 THICK)
(REF. DART SPEC. M304S11GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D3516-11 = 0.09 lbs
D3516-13 = 0.10 lbs

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MFG. APPR.		D3516	SHEET 4 OF 4
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45428B